

[illegible]

Page 1

**Accept**

[illegible]**Setup Start**[illegible]

**Stop**

[illegible]

1. **Author(s):** [Redacted]  
 2. **Title:** [Redacted]  
 3. **Journal:** [Redacted]  
 4. **Volume:** [Redacted]  
 5. **Issue:** [Redacted]  
 6. **Pages:** [Redacted]  
 7. **Year:** [Redacted]  
 8. **DOI:** [Redacted]  
 9. **URL:** [Redacted]  
 10. **Abstract:** [Redacted]

**Cust Item ID:**[illegible]

**Customer:**

**Reference:**

**Process Plan:** JMF.

**Date:** 11-05-20

**Tooling:**

Date:

Run Start

**Abstract**

**QC:**

Date:

**SPC (Y/N):**

Date:

**Stop**

**Abstract**

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 69832**

Thursday, May 19, 2011 3:20:04 PM



Page 2

Item ID: D4039-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Bracket Assembly

Start Date: 5/20/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/3/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/13 JJ  
MF  
11-06-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, May 19, 2011 3:19:59 PM

Page 1

Work Order ID: 69832

Parent Item: D4039-041

Parent Item Name: Fwd Bracket Assembly





Start Date: 5/20/2011

Required Date: 6/3/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 09.12.15 verified by:EC  
B:AS PER ECN 10-563 10-09-28 JLM VERIFIED BY:DD IPP REV

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
 D4039-1 Fwd Bracket		Manufactured	No			100	Each	0.0000	1	2			
 D2690-6 Lanyard Assembly		Manufactured	No			100	Each	17.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST020				17					
				66873				17					
 BLRS-010 Pip Pin		Purchased	No			100	Each	6.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				ST283				6					
				116348				6					
 MS27039-1-11 Screw		Purchased	No			100	Each	69.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>	<u>Loc Code</u>				
				MEZZ				69					
				9662				69					

B69833

(2X)

EP 5/11/06/10

EP 5/11/06/10

EP 5/11/06/10

EP 5/11/06/10

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, May 19, 2011 3:19:59 PM

Page 2

Work Order ID: 69832



Parent Item: D4039-041



Parent Item Name: Fwd Bracket Assembly

Start Date: 5/20/2011

Required Date: 6/3/2011

Start Qty: 2.00

Required Qty: 2.00

MS21042L3

Purchased

No

100

Each

2,180.000

1

2



Nut

*4/24/06/10*

Location

Loc Qty

Loc Code

ST300

2180

116391

11

116540

203

116549

766

117441

800

117601

400

*2*

NAS1149D0363J

Purchased

No

100

Each

2,599.000

3

6



Washer

*4/24/06/10*

Location

Loc Qty

Loc Code

ST298

2599

116583

599

117291

1000

117505

500

117601

500

*6*

Thursday, May 19, 2011 3:19:59 PM

Shop Packet Print

Page 2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

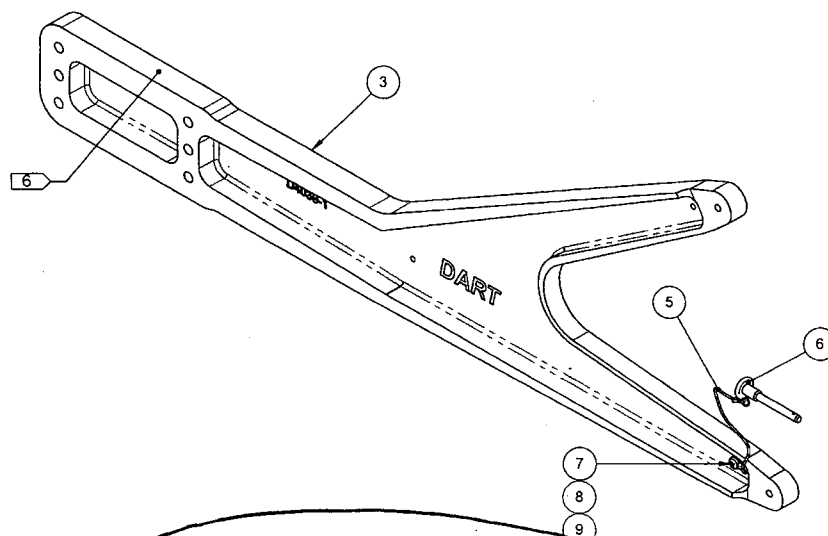
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

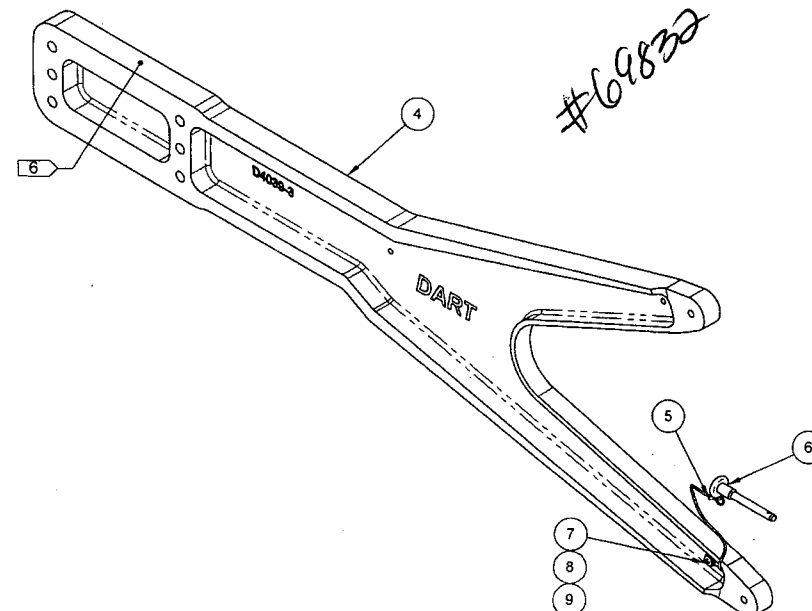
**NOTE:** Date & initial all entries



ITEM NO.	QTY. -041	QTY. -043	PART NUMBER	DESCRIPTION
1	X		D4039-041	FWD BRACKET ASSEMBLY
2		X	D4039-043	AFT BRACKET ASSEMBLY
3	1		D4039-1	FWD BRACKET
4		1	D4039-3	AFT BRACKET
5	1	1	D2690-6	LANYARD
6	1	1	BLRS-010	PIP PIN
7	1	1	MS27039-1-11	SCREW
8	1	1	MS21042L3	NUT
9	3	3	NAS1149D0363J	WASHER



**D4039-041 FWD BRACKET ASSEMBLY**



**D4039-043 AFT BRACKET ASSEMBLY**

**RELEASED**  
2010-09-37

- NOTES:**  
 1) MATERIAL: N/A  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: N/A  
 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1  
 7) WEIGHT: N/A

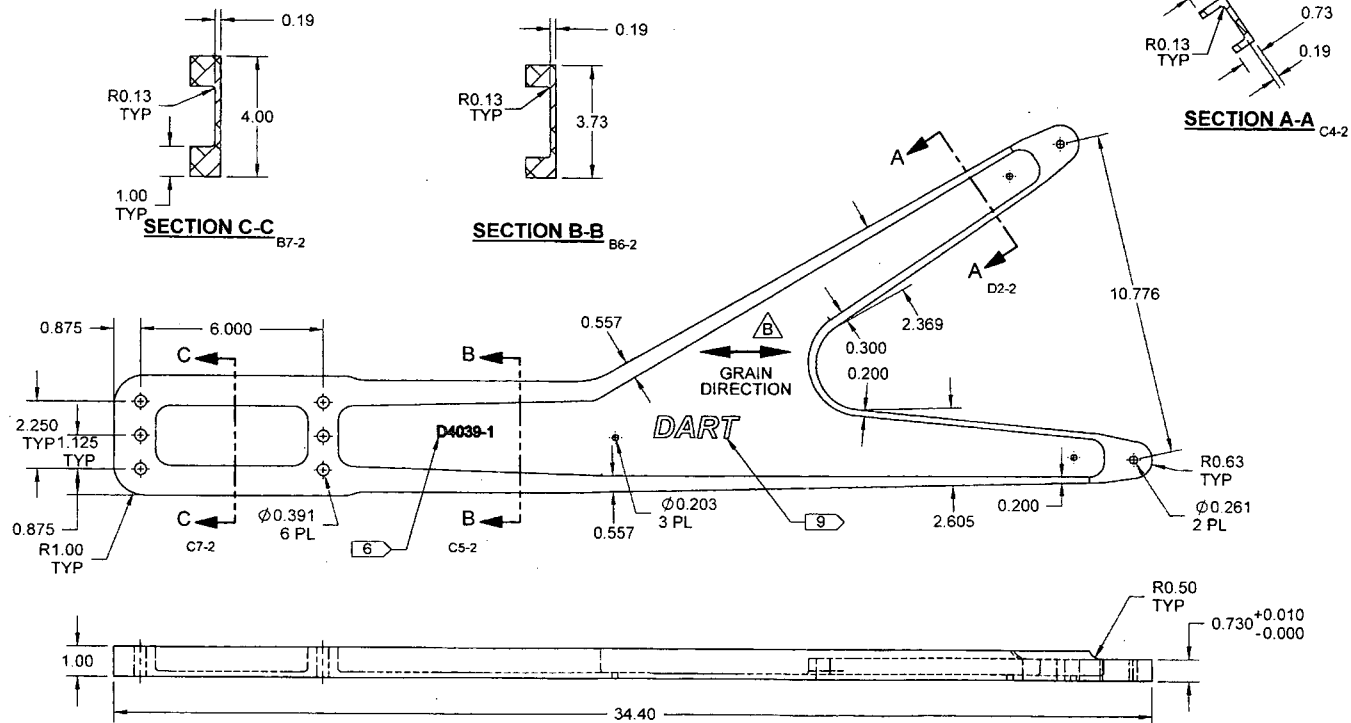
**B**

B	REVISE HOLE SIZE ON D4039-3 FROM 0.191 TO 0.203, ZN B6-3	HS	10.04.28
A	NEW ISSUE	BY	09.12.14
REV.	DESCRIPTION	DATE	
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.04.28		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4039** REV. B  
 TITLE **BRACKET** SHEET 1 OF 3  
 SCALE NTS

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**D4039-1 FWD BRACKET**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 1.000 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC M6061T6S1.000
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE P/N AND BATCH NUMBER IN THIS AREA TO MAX  
DEPTH OF 0.010 WITH MIN TOOL RADIUS OF 0.010
- 7) WEIGHT: 6.64 lbs
- 8) MACHINE PER DART SOLIDWORKS PART "D4039-1 REV.B SLDPR1"
- 9) ENGRAVE DART LOGO IN THIS AREA TO MAX DEPTH OF 0.015 WITH MIN TOOL RADIUS OF 0.250

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4039	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		BRACKET	NTS
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**RELEASED**  
2010-09-27

